

Work Order ID 151580***151580***

Page 1

Thursday, September 29, 2016 11:43:48 AM

Item ID: D4365-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bar Weldment

Start Date: 9/29/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/6/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: demDate: 10/09/29

Tooling:

Date:

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4365	B								

100

0.00

100

Cold Saw

Memo

0.00

Hyd Mech

Cut D4365-3 blanks at 66.00"

EXTRA MATERIAL WILL TRIM OFF AT ASSEMBLY

04 Q.L 17-02-15

110

0.00

110

Large Fab

Memo

0.00

Large Fab

1- USE GRINDER TO CHAMFER END AS PER DWG .

SEE NOTE 8 FOR SURFACE BUILDUP

FOR AUTOMATED WELDING USE 8259 HARDCOAT

BATCH: M 1365514 Q.L/R 17-02-16

151580

Thursday, September 29, 2016 11:43:48 AM

LOCATION: WA001

FEB 16 2017

Picklist Print

Thursday, September 29, 2016 11:43:47 AM

Page 1

Work Order ID: 151580

151580

Parent Item: D4365-043

D4365-043

Parent Item Name: Bar Weldment

Start Date: 9/29/2016

Required Date: 10/6/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV: 15.10.16 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased			No		f	47.8460		23.15789			
M304B0 250x0 500									**	Q.L	17-02-15		
304 BAR .250 x .500													

Location

Loc Qty

Loc Code

WA002

47.846

134172

6

m133596

38.948

m133923

1.85

m134526

1.048

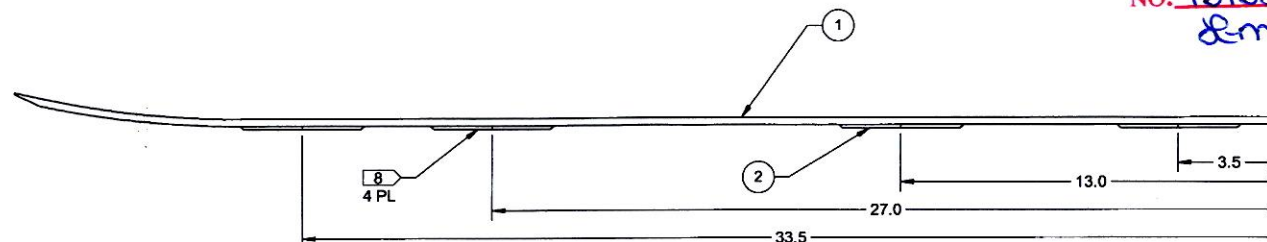
M136163

2323

ITEM	QTY	P/N	DESCRIPTION
	X	D4365-041	BAR WELDMENT
1	1	D4365-1	BAR
2	A/R	8259/2059B	HARD SURFACING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 151580
Em 16/09/29



B D4365-041 BAR WELDMENT

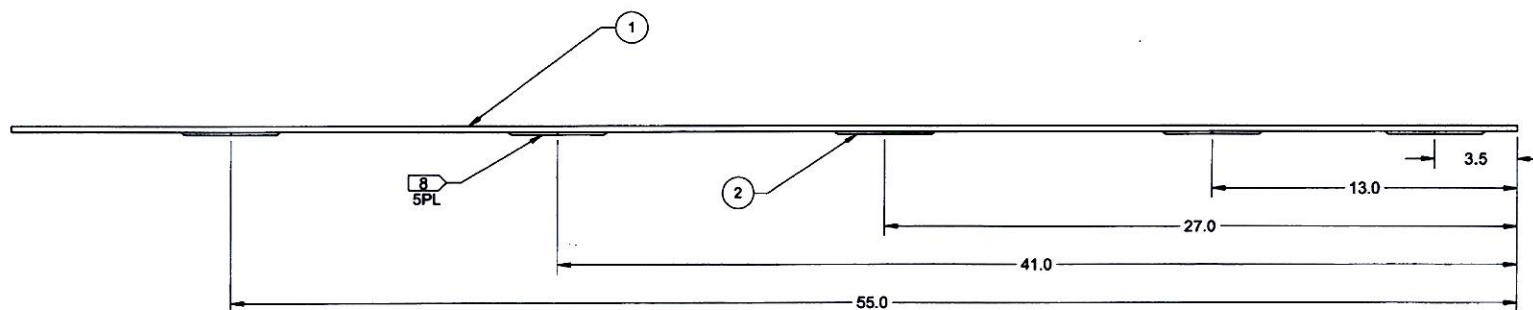
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4365-041 PER QSI 044 6.1
- 7) WEIGHT: D4365-041 = 1.92 lbs
- 8) BUILDUP HARD SURFACING 0.18 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR, BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

B	ADD D4365-041/043 WELDMENTS, MODIFY D4365-1 (ADD FORMING DETAILS, REMOVE 0.188 HOLES), MODIFY D4365-3 (REMOVE 0.188 HOLES), ADD D4365-1F, ADD AUTOMATED WELDING NOTE	DB	16.05.24
A	NEW ISSUE	SC	11.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	EUGENE, OR	
CHECKED	WM	DRAWING NO.	REV. B
MFG. APPR.	DD	D4365	SHEET 1 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARBAR	NTS
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RELEASED
2016-06-16
EW 16-574
APPROVED

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4365-043	BAR WELDMENT
1	1	D4365-3	BAR
2	A/R	8259/2059B	HARD SURFACING



B D4365-043 BAR WELDMENT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N *D4365-043 PER QSI 044 6.1
- 7) WEIGHT: D4365-043 = 2.79 lbs
- 8) BUILDUP HARD SURFACING 0.18 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR, BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

B

RELEASE
2016-06-16

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	EUGENE, OR	
CHECKED	WM	DRAWING NO.	REV. B
MFG. APPR.	DD	D4365	SHEET 2 OF 3
APPROVED	WM	TITLE	SCALE
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